

25

Date: Friday, 5/25/2007 12:46:23 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE  
 Job Number : 32665  
 Estimate Number : 10553  
 P.O. Number : N/A Part Number : D206667103  
 This Issue : 5/25/2007 S.O. No. : N/A Drawing Number : D206-667-143 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 5/25/2007 Type : LANDING GEAR Drawing Revision : B  
 Previous Run : 32664 Material : N/A  
 Due Date : 6/20/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : AP 705.28  
 Comment : Est Rev: R 05.09.01 Add holes for compatibility with Bell  
 Skidtubes KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



KJ 07.06.04

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

S. 02/01/04

2.0

D6002115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6002-115

Crosstube

B29113

Check OD = 2.250"; ID = 1.750"

S. 07/06/21

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

S. 07/06/21

4.0

QC1

INSPECT ALL DIM TO DIM SHEET


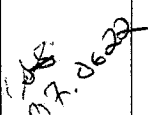
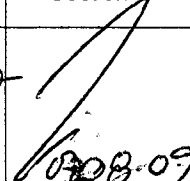
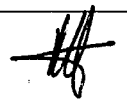
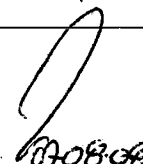


Comment: INSPECT ALL DIM TO DIM SHEET

S. 07/06/21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:            |      | WORK ORDER NON-CONFORMANCE (NCR)   |   |                                 |  |  |   |  |
|-----------------|------|--|---|---------------------------------|--|--|---|--|
| DATE            | STEP | Description of NC<br>Section A   | Corrective Action Section B   |                                 |  | Verification<br>Section C  | Approval<br>Chief Eng   | Approval<br>QC Inspector   |
|                 |      |  | Initial<br>Chief Eng  | Action Description<br>Chief Eng | Sign &<br>Date   |  |   |  |
| 07/06/22<br>S.B | 5.0  | one coffee was tapered from 2.242 to 2.232. The cause was I changed insert of force and I think I didn't tight enough. So the insert move inside the holder. | <br>07-08-08 | ACCEPTABLE<br>DEVIATION.        | <br>07-06-22 | <br>07-08-09 | <br>07-08-08 | <br>07-08-08 |
|                 |      |  |   |                                 |  |  |   |  |
|                 |      |  |   |                                 |  |  |   |  |

Date &amp; initial all entries

Date: Friday, 5/25/2007 12:46:24 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32665

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

2.8 07/06/22

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

2.8 07/06/22

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/08/22

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

07-8-17

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/22

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-8-28

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

07-8-28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:46:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 32665

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

Er 02/08/22 (41)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 28-31

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Check holes

Er 02/08/31

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 02/08/31

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:46:24 PM  
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## Process Sheet

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Drawing Name: 206L FWD X-TUBE

Job Number: 32665

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 4513 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

*C207109104 ①*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*EP 07/09/12 ①*

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

*07-09-12 ①*

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*7 ml 07 09 12 ①*

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*RT 07-09-13*

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

*26650 (6 inch no more 4 inch) RT 07-09-13*

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

*32512 RT 07-09-13*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



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Drawing Name: 206L FWD X-TUBE

Job Number: 32665

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

32777

8T 07-09-13

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

28792

8T 07-09-13

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

105057

8T 07-09-13

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

104902

8T 07-09-13

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

} 8T 07-09-13  
8T 07-09-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

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Job Number: 32665

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 2/09/14

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850

SP

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105547

SP

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-7A

Description Batch

Bolt

M104603

SP

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description Batch

Bolt

M19522

SP

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

18 AN960JD516

Description Batch

Washer

M104151

7/9/14 SP

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   P   Date: 07/01/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/09/14

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev:

B

07/14/14

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/15/14

Job Completion



07/09/17

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |                                  |
|--|----------------------------------|
| <b>DART AEROSPACE LTD</b>                              | <b>Work Order:</b> 32665         |
| <b>Description:</b> Crosstube Assembly (206L High Fwd) | <b>Part Number:</b> D206-667-143 |
| <b>Inspection Dwg:</b> D206-667-143 Rev: B             | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

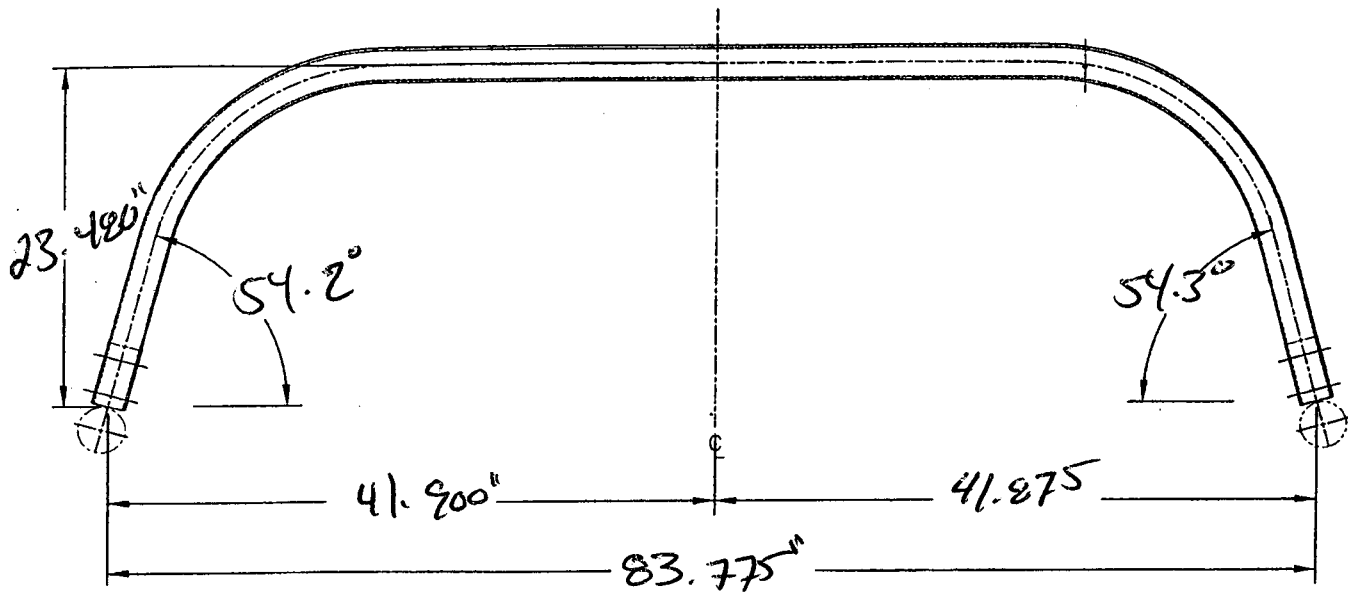
| Inspection Sheet<br>Drawing Dimension | Tolerance   | Actual<br>Dimension | Accept      | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-------------|---------------------|-------------|--------|-------------------------|----------|
| SIDE A                                | 2.240       | +0.005/-0.000       | 2.242/2.239 |        |                         |          |
|                                       | 1.982       | +0.005/-0.000       | 1.982       |        |                         |          |
|                                       | 2.019       | +0.005/-0.000       | 2.020       |        |                         |          |
|                                       | 2.058       | +0.005/-0.000       | 2.059       |        |                         |          |
|                                       | 2.097       | +0.005/-0.000       | 2.099       |        |                         |          |
|                                       | 2.136       | +0.005/-0.000       | 2.137       |        |                         |          |
|                                       | 2.176       | +0.005/-0.000       | 2.177       |        |                         |          |
|                                       | 2.201       | +0.005/-0.000       | 2.202       |        |                         |          |
|                                       | 0.125       | +/-0.010            | .125        |        |                         |          |
|                                       | 0.400 x 30° | +/-0.010            | .400        |        |                         |          |
|                                       | R0.063      | +/-0.010            | .063        |        |                         |          |
|                                       | R0.500      | +/-0.010            | .500        |        |                         |          |
|                                       | 4.438       | +/-0.030            | 4.439       |        |                         |          |
|                                       |             |                     |             |        |                         |          |
| SIDE B                                | 104.98      | +/-0.020            | 104.960     |        |                         |          |
|                                       | 2.240       | +0.005/-0.000       | 2.242       |        |                         |          |
|                                       | 1.982       | +0.005/-0.000       | 1.983       |        |                         |          |
|                                       | 2.019       | +0.005/-0.000       | 2.020       |        |                         |          |
|                                       | 2.058       | +0.005/-0.000       | 2.059       |        |                         |          |
|                                       | 2.097       | +0.005/-0.000       | 2.098       |        |                         |          |
|                                       | 2.136       | +0.005/-0.000       | 2.137       |        |                         |          |
|                                       | 2.176       | +0.005/-0.000       | 2.177       |        |                         |          |
|                                       | 2.201       | +0.005/-0.000       | 2.201       |        |                         |          |
|                                       | 0.125       | +/-0.010            | .125        |        |                         |          |
|                                       | 0.400 x 30° | +/-0.010            | .400        |        |                         |          |
|                                       | R0.063      | +/-0.010            | .063        |        |                         |          |
|                                       | R0.500      | +/-0.010            | .500        |        |                         |          |
|                                       | 4.438       | +/-0.030            | 4.432       |        |                         |          |

|                          |                                |                            |     |
|--------------------------|--------------------------------|----------------------------|-----|
| <b>Measured by:</b> J.E. | <b>Audited by:</b> [Signature] | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 07/06/21    | <b>Date:</b> 07/06/21          | <b>Date:</b>               | N/A |

| Rev | Date     | Change                       | Revised by | Approved    |
|-----|----------|------------------------------|------------|-------------|
| A   | 04.05.06 | New Issue (P/O D206-667-103) | KJ/RF      |             |
| B   | 06.03.09 | Dwg Rev updated              | KJ/JLM     | [Signature] |

|  |  |              |              |
|--|--|--------------|--------------|
| DART AEROSPACE LTD                     |  | Work Order:  | 32665        |
| Description: Crosstube High Fwd (206L) |  | Part Number: | D206-667-103 |
| Inspection Dwg: D206-667-143 Rev: B    |  | Page 1 of 1  |              |

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 23.46 | 23.58 |
| 1/2 Span           | 41.86 | 41.98 |
| Angle              | 54    | 56    |
| Total Span         | 83.72 | 83.96 |



| Comments |
|----------|
|          |
|          |
|          |
|          |
|          |

|                 |                    |
|-----------------|--------------------|
| QC15 Inspection | <i>[Signature]</i> |
| Date            | 07/02/2008         |

| Rev | Date     | Change    | Revised by               | Approved           |
|-----|----------|-----------|--------------------------|--------------------|
| A   | 07.02.06 | New Issue | KJ/JM <i>[Signature]</i> | <i>[Signature]</i> |





|                  |                 |   |                        |
|------------------|-----------------|---|------------------------|
| DESIGN<br>PH     | DRAWN BY<br>PH  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                   |                        |
| CHECKED<br>HDS   | APPROVED<br>HDS | DRAWING NO.<br>D206-667-143   | REV. B<br>SHEET 1 OF 3 |
| DATE<br>05.07.26 |                 | TITLE<br>CROSSTUBE ASS'Y (206L HIGH FWD) NTS                        |                        |
| A                | 00.11.17        | NEW ISSUE   |                        |
| B                | 05.07.26        | ADD HOLES AND NUT PLATES FOR<br>COMPATABILITY WITH BHT/AA SKIDTUBES |                        |

RELEASED  
05-07-26

UNDER REVIEW

05-08-10 PH

re-draw detail F  
PH

07.05.02

| Qty | Part Number   | Description                        |
|-----|---------------|------------------------------------|
| X   | D206-667-143  | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 1   | D6002-115     | CROSSTUBE                          |
| 2   | D2873-043     | NUT PLATE                          |
| 2   | D2873-045     | NUT PLATE                          |
| 2   | D2856-400-694 | ABRASION STRIP                     |
| 2   | D2891-1       | SUPPORT                            |
| 14  | MS20601AD4W8  | RIVET (OR NAS9302B-4-8)            |
| 4   | MS21920-20    | CLAMP                              |

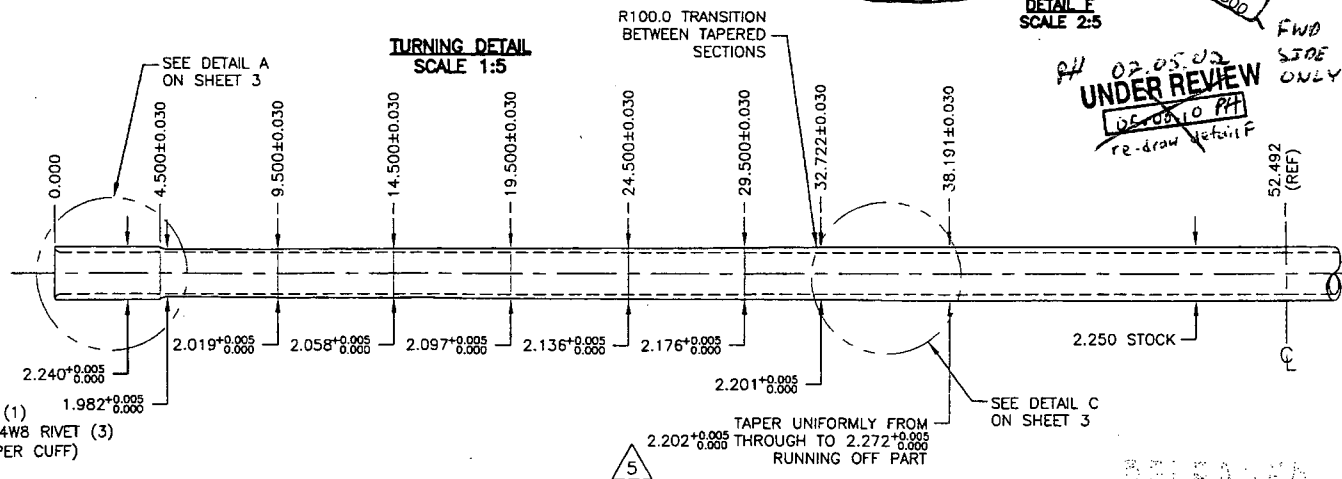
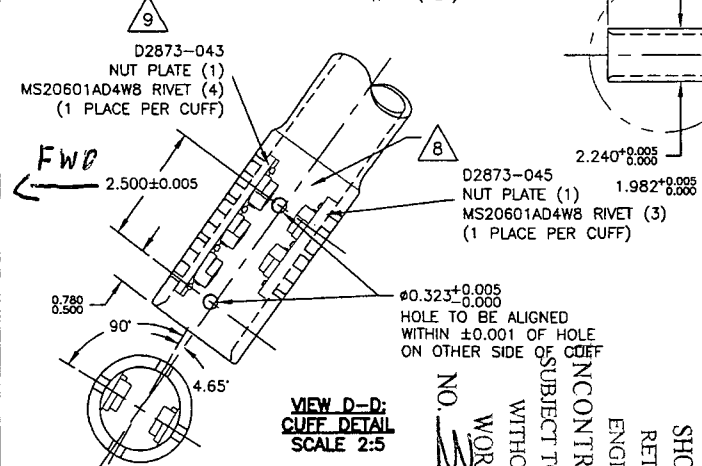
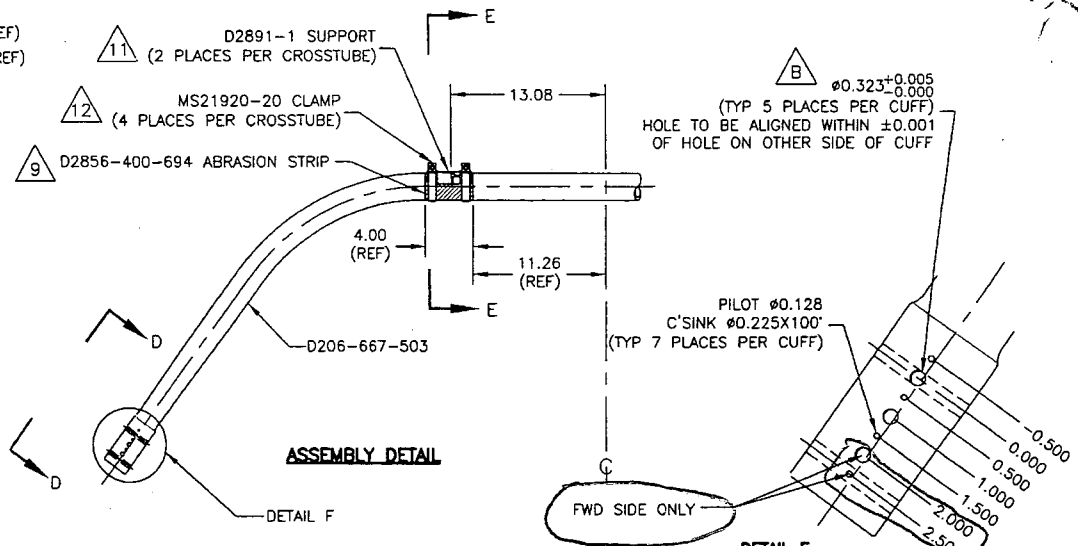
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115  
FINISHED LENGTH =  $104.98 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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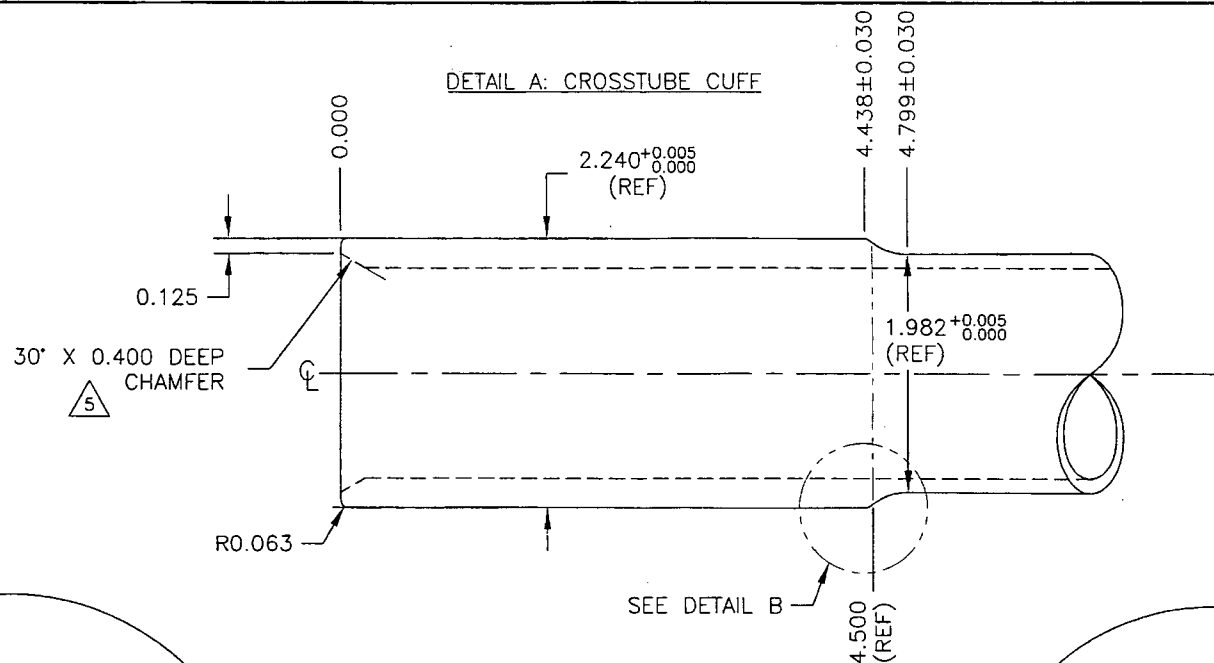


PH 02.05.02 SIDE ONLY  
UNDER REVIEW  
05.06.10 PH  
Lead Detail F

05.07.26

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| DATE<br>05.07.26   |  | TITLE<br>CROSSTUBE ASS'Y (206L HIGH FWD) 1:10 |                  |                             |   |

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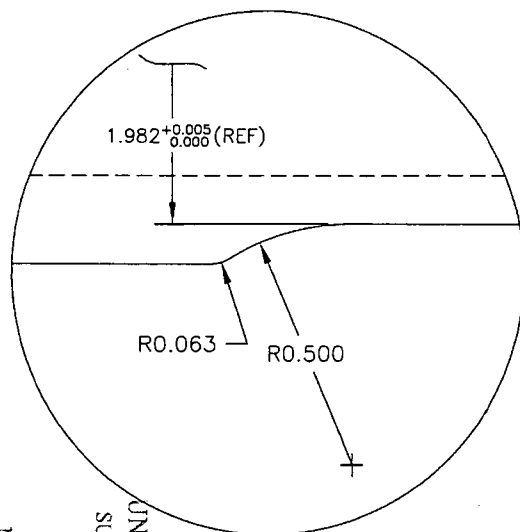


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06.08.08 PH

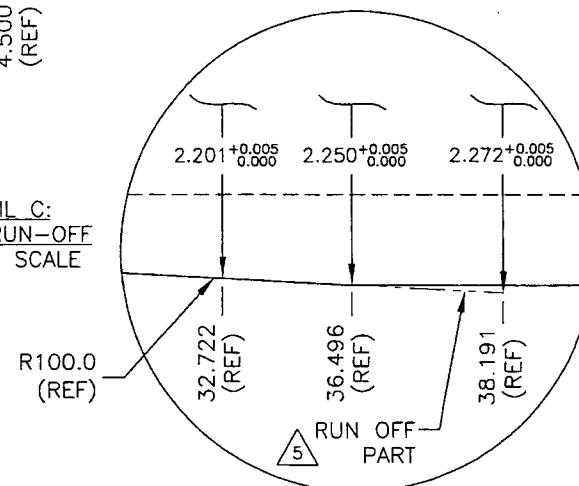
Redraw detail F

PH 07.05.02



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



NO. 22665

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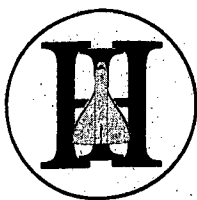
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|  |  | PH       | PH       | D206-667-143   | SHEET 3 OF 3 |
|  |  | DATE     |          | TITLE  | SCALE        |
|  |  | 05.07.26 |          | CROSSTUBE ASS'Y (206L HIGH FWD)                                | 1:1          |





# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37304

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of four (4) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D212-664-101 S/N's B32678 & B32677

Qty. (1) P/N D206-667-103 S/N B32665

Qty. (1) P/N D407-667-205 S/N B32686

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on four (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLETCHER

DATE September 11, 2007

INSPECTION  
STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

4513

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT